

CLAIMS

1. A method of securing an end fitting to an end of a hose having an outer braid and a plastic liner, the method including the steps of:-

i) providing a hollow end fitting for a hose, the end fitting having a spigot and a sealing face;

ii) inserting the spigot of the end fitting between the braid and the liner and bring the liner end through said hollow end fitting and flaring out the liner end to form a plastic sealing face;

iii) processing the assembly so formed in such a manner as to cause the flared liner end to form a shape which includes a bead on the liner surface and which has its inside edge squared off.

2. A method as claimed in claim 1 wherein the bead is concentric and allows the rubber seal previously used to be dispensed with.

3. A method as claimed in either of claims 1 or 2 wherein the end fitting comprises a PTFE lined end fitting, in which the PTFE hose liner is passed through the bore of the end fitting, and is then flared out.

4. A method as claimed in claim 3 wherein the flared out portion is then hot formed, e.g. by pressing with a heated tool, in order to form a shape which includes a "bead" of PTFE, and has the inside edge squared off.

5. A method as claimed in claim 4 wherein the bead is formed with a corresponding bead machined in to the face of the steel.

6. A method as claimed in claim 4 wherein the bead is formed without a corresponding bead machined in to the face of the steel.



7. A method as claimed in any of claims 1 to 6 wherein the processing step (iii) also results in the liner assuming a square internal corner where it goes into the flared sealing face, thus avoiding any entrapment zone.

8. A method as claimed in any of claims 1 to 7 wherein step (iii) is a hot coining process which causes the plastic liner to assume the shape of the rubber seal.

9. A plastic lined hose having secured to an end thereof a hollow end fitting having a spigot and a sealing face, wherein the spigot is located between the braid and the liner, and the liner end passes through the end fitting and is flared out to form a plastic sealing face overlying the sealing face of the end fitting to form a shape which includes a bead on the liner surface and which has its inside edge squared off.

10. A hose as claimed in claim 9 wherein the face of the of the seal includes a bead to ensure concentric location of the jointed component, and provides a squared-off inside edge to eliminate an entrapment zone.